

Date: Thursday, 5/10/2007 2:25:47 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 32283	
Estimate Number : 10330	
P.O. Number : <i>NA</i>	Part Number : D2746
This Issue : 5/10/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2746 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>NA</i> Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 30141	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 5/30/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>26</i> Um: Each
Comment : Est Rev: D 02.10.24 Re-format KJ	
Est Rev: E 06-03-21 as Per Rev C JLM	
Est Rev: F 06-06-12 Now On Waterjet JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S20GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 0.4263 sf(s)/Unit Total : 10.6575 sf(s)  
 1010/1025/A21/6aA .040" SHEET  
 (M1010S20GA)  
 Batch: *M104184*

*SAD 07/05/12 26*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D2746  
 Dwg Rev: *C*  
 Prog Rev: *C*

*SAD 07/05/12*

2-Deburr if necessary

*26*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD 07/05/12*

*26*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*SAD 07-05-13*

*26*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Deburr if necessary.

*[Signature] 07/05/15 26*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: RD Date: 07/05/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: WEARSHOE

Job Number: 32283

Part Number: D2746

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on CNC Brake as per Dwg D2746 using Jigs DT8261and DT8326

2-Form joggle on Punch as per Dwg D2746 using Jig DT8158Identify as D2746

MF 07-05-16

MF 07-05-16

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/05/16

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

MF 07-05-17

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 07/05/17

26X

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

17-17

MF 07/05/17

26x

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MF 07/05/18

26

Job Completion



W 07/05/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

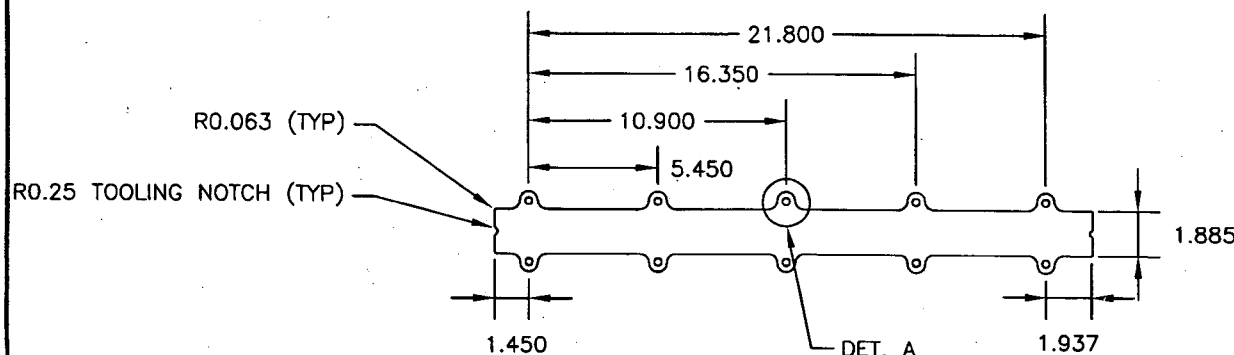


**DART**

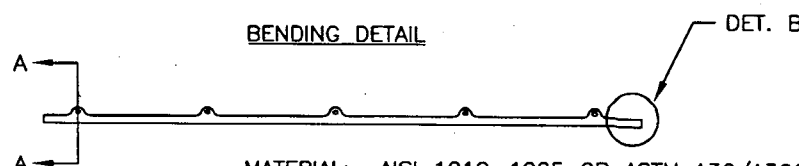
RELEASED  
06-02-07

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
F41	F41	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D2746
DATE	TITLE	REV. C
06.01.12	WEARSHOE	SHEET 1 OF 1
A	98.04.16	NEW ISSUE
B	98.08.18	RE-DESIGN
C	06.01.12	ENLARGE HOLES TO IMPROVE FIT

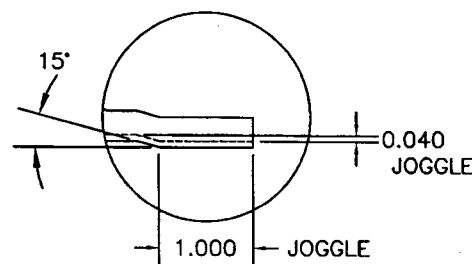
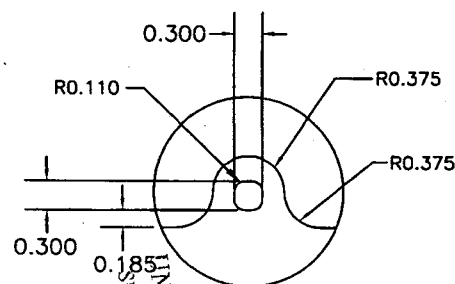
FLAT PATTERN



BENDING DETAIL



MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008  
OR CSA G40-21, 38W/44W/50W/60W/70W  
SERIES STEEL, 20 GAUGE (0.040 THICK)



SECTION A-A

DETAIL B

NOTES

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL, 20 GAUGE (0.040 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) THIS PART CAN BE MADE BY MODIFYING D2656-21

